

Work Order ID 61321

August 17, 2010 3:47:24 PM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 8/17/10 Start Qty: 1.00



Cust Item ID:

Required Date: 9/02/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: CZ Date: 10/8/17

Tooling:

Date:

Stop



QC: Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A

110

0.00



CNC Bend 1

CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

Memo

0.00

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

IX MB 10-08-19

91.5
13.4
104.9
32.0
136.9
+ 1.75
137.65
3.500
141.15
141.5
1.750
143.900

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

1

0

2L 10/08/25

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/08/25

(YU)

W/O:		WORK ORDER CHANGES					
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Reference:

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QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00

Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R Aluminum Rod

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R Aluminum Rod

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Debur

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580.
Debur holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

BE 10/8/26

BE 10/8/26

BE 10/8/30

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00		8/10/08/31					
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8/10/08/31		(X)			
170 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.	0.00 0.00							i BH D-9-1

W/O:		WORK ORDER CHANGES					
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[illegible]

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[illegible][illegible]

(b) (5) DPP, (b) (7)(C), (b) (7)(D)

**Cust Item ID:**

Customer:

Abstract



Date: _____

**Insp.
Stamp**

12.00

Quality Control

Σελος

④

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

0.00



HandFinish

Hand Finishing

Memo

0.00

=> M 10/09/08

X1

Ø

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R ☐ ☐ ☐ Sikaflex-291 ☐ 111511 ☐ ☐
Sikaflex expire date: 11/10

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R ☐ ☐ ☐ Sikaflex-291 ☐ 111511 ☐ ☐
Sikaflex expire date: 11/10

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: 1105028

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024	0.00 0.00		8/10/09/09					
220 Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPPD205-634-041 Location: _____ PPP Rev: <u>PN 60921</u>	0.00 0.00							
230 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

Picklist Print

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Page 1

Work Order ID: 61321

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 8/17/10

Required Date: 9/02/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2580-1

Manufactured

No

110

Each

7.0000

1

1



205 Skidtube bent detail

Location

Loc Qty

Loc Code

LG

6

57028

1

60956

1

61190

2

61191

2

ST046

1

59856

1

D2576-3

Manufactured

No

140

Each

84.0000

1

1



Step (maching detail)

Location

Loc Qty

Loc Code

LG

84

46661

36

52215

48



B-60956 MB 10-08-19
 60956 57028

1X



1 BE 10/08/26

W/O:		WORK ORDER CHANGES					
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Work Order ID: 61321



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 8/17/10

Required Date: 9/02/10

Start Qty: 1.00

Required Qty: 1.00

D2579 Manufactured No 140 Each 295.0000 20 20



Crossbolt Spacer

Location	Loc Qty	Loc Code
LG	295	
57052	5	
57348	4	
58433	2	
59113	182	
60845	102	

20 SE 10/08/26

D2855 Manufactured No 200 Each 77.0000 1 1



Cap

Location	Loc Qty	Loc Code
FP6	1	
56613	1	
ST026	76	
50513	1	
50770	28	
51539	2	
53791	45	

1 10/09/08

AN3-5A Purchased No 200 Each 1,534.000 2 2



Bolt

Location	Loc Qty	Loc Code
ST350	1534	
105057	534	
115016	500	
115371	500	

2 10/09/08

x2

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Work Order ID: 61321



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 8/17/10

Required Date: 9/02/10

Start Qty: 1.00

Required Qty: 1.00

AN960JD10L NAS1149D0332J Purchased

No

200

Each

2,623.000

2

2



HL 10/09/08

Washer

Location

Loc Qty

Loc Code

ST348

2623

110985

2623

x2

ALS7-1032-130

Purchased

No

200

Each

878.0000

50

50



HL 10/09/08

Insert

Location

Loc Qty

Loc Code

FP

861

MA114723

x50

115079

861

ST282

17

113238

17

AN3C4A

Purchased

No

200

Each

2,091.000

50

50



HL 10/09/08

BOLT

Location

Loc Qty

Loc Code

ST303

500

115438

500

x50

ST350

1591

114108

14

114416

12

114523

2

114941

563

115300

1000

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Replacement Skidtube

Start Date: 8/17/10

Required Date: 9/02/10

Start Qty: 1.00

Required Qty: 1.00

AN960C10L NAS1149C0332 Purchased No

200 Each 29.0000 50 50



washer



HL 10/09/08

Location

Loc Qty

Loc Code

ST245

29

107534

29

1115000

X50

D3566-13 Manufactured No

200 Each 30.0000 1 1



Gasket



HL 10/09/08

Location

Loc Qty

Loc Code

FP012

30

59661

22

60209

8

X1

D3566-5 Manufactured No

200 Each 32.0000 1 1



Gasket



HL 10/09/08

Location

Loc Qty

Loc Code

FP

22

60869

22

FP015

10

59158

10

X1

D3566-1 Manufactured No

200 Each 23.0000 2 2



Gasket



HL 10/09/08

Location

Loc Qty

Loc Code

FP

9

60857

9

FP015

14

57715

2

60202

12

X2

B61656

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Page 4

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Parent Item Name: Replacement Skidtube

Start Date: 8/17/10

Required Date: 9/02/10

Start Qty: 1.00

Required Qty: 1.00

D3564-11 Manufactured No

200

Each

4.0000

1

1



Wearshoe



HL 10/09/08

Location

Loc Qty

Loc Code

FP019

4

B60302

xl

59941

4

D3564-13 Manufactured No

200

Each

27.0000

1

1



Wearshoe



HL 10/09/08

Location

Loc Qty

Loc Code

FP17

27

xl

59660

15

60862

12

D3564-9 Manufactured No

200

Each

20.0000

1

1



Wearshoe



HL 10/09/08

Location

Loc Qty

Loc Code

FP

1

55334

1

FP019

19

59201

6

60236

13

xl

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Required Date: 9/02/10

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

200

Each

23.0000

1

1



Wearshoe



JH 10/09/08

LocationLoc QtyLoc Code

FG

1

34806

1

FP19

2

57525

1

58709

1

FP-19

20

59157

8

(60868)

12

x1

D2594-3

Manufactured No

200

Each

291.0000

16

16



O-Ring, 205 Skidtube



JH 10/09/08

LocationLoc QtyLoc Code

FP

291

55546

19

58191

12

(59358)

260

x16

D2594-1

Manufactured No

200

Each

355.0000

16

16



Plug, 205 Skidtube



JH 10/09/08

LocationLoc QtyLoc Code

FP

183

42807

112

55002

71

FP14

172

58434

15

(59110)

157

x16

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DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 *[Signature]*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 61321
62108/17

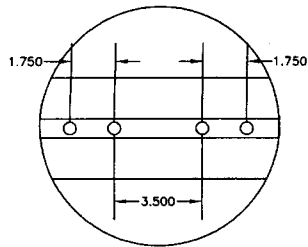
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

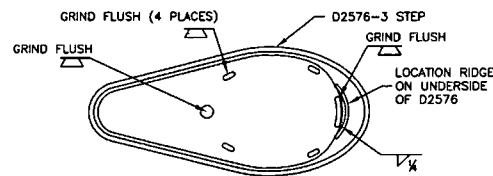
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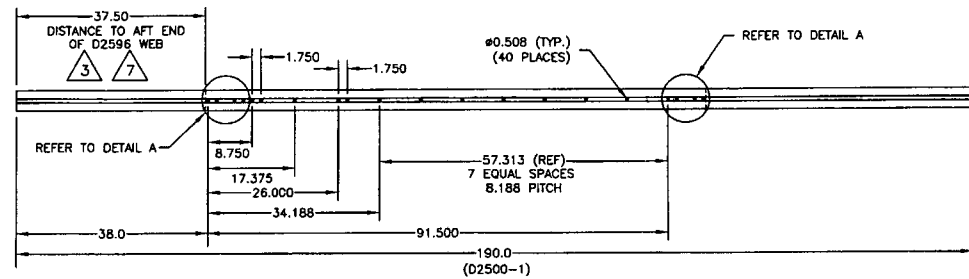
DETAIL A
SCALE 5:24



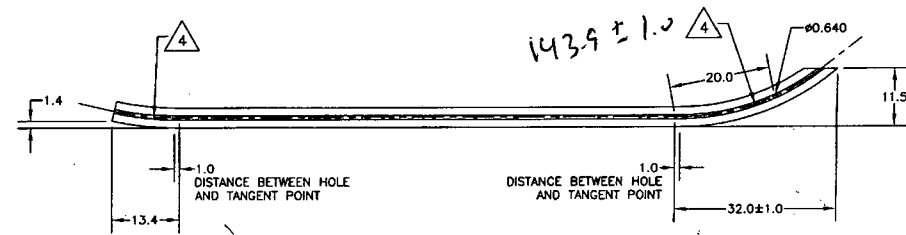
DETAIL B
SCALE 5:24



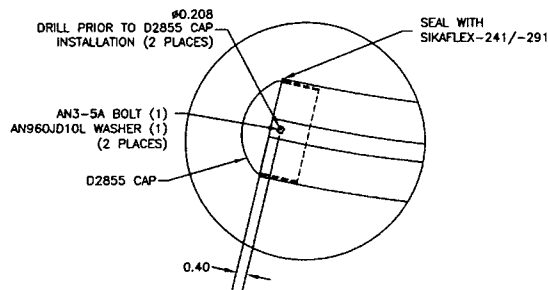
D2580-1 DRILLING DETAIL



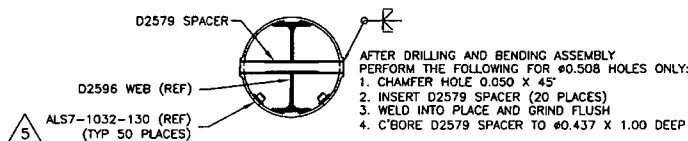
D2580-1 BENDING AND CUTTING DETAIL



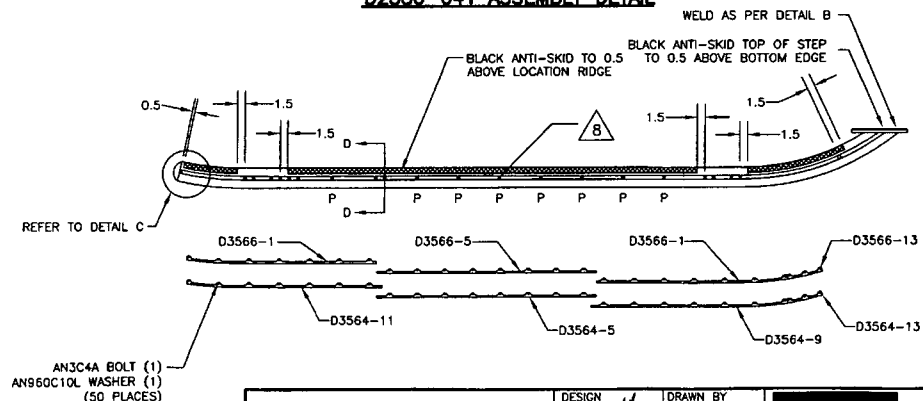
DETAIL C
SCALE 5:24



SECTION D-D
SCALE 5:24



D2580-041 ASSEMBLY DETAIL



D2580-041 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

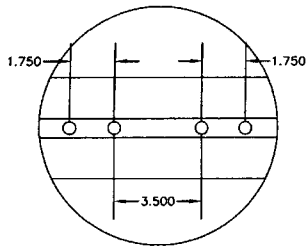
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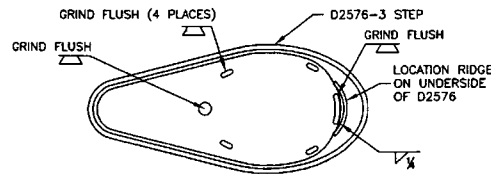
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CHECKED	APPROVED	DRAWING NO.	REV. D
DATE	TITLE	D2580	SHEET 2 OF 3
07.02.27	205 SKIDTUBE ASSEMBLY	SCALE	1:24

DETAIL E
SCALE 5:24

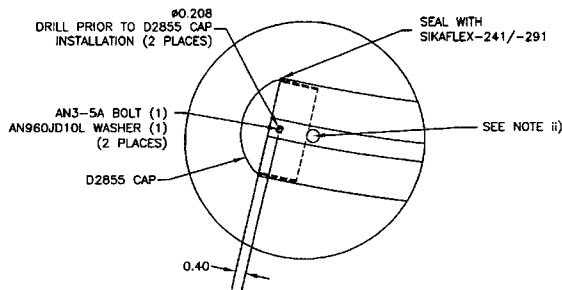


DETAIL F
SCALE 5:24

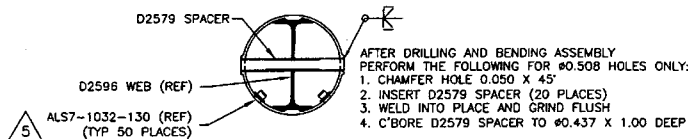


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07.02.27

DETAIL G
SCALE 5:24



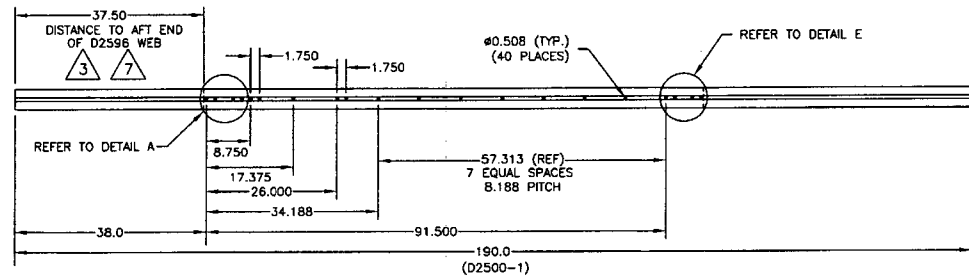
SECTION H-H
SCALE 5:24



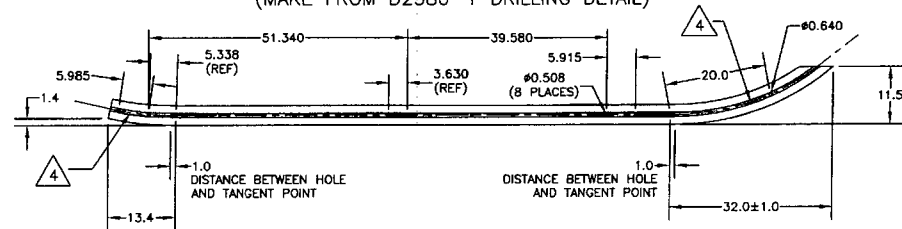
D2580-045 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

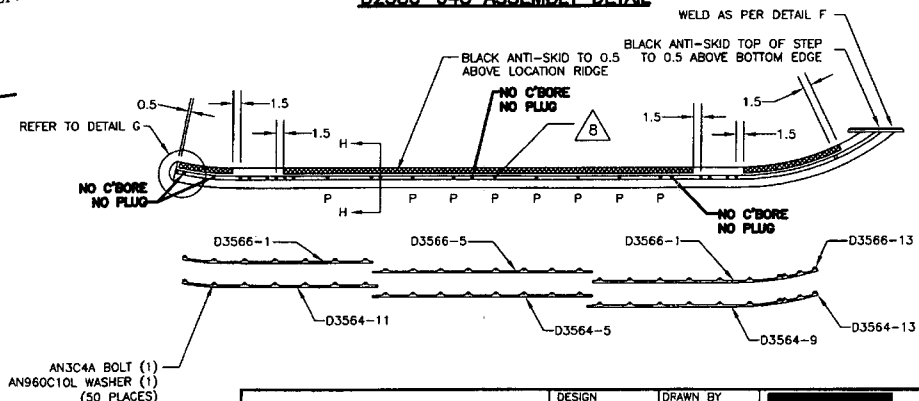
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



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CHECKED <i>RH</i>	APPROVED <i>RH</i>	DRAWING NO. D2580	REV. 0 SHEET 3 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24	

NO. 238

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 61352
Part number: D205-634-041
Description: 205 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier: Paul D. Dub Date of Test Coupon 10.08.25
Welder: Barclay Elliott Date of Test Coupon 10.09.25

The above named individual is qualified in accordance with AWS D17.1.2001 to weld